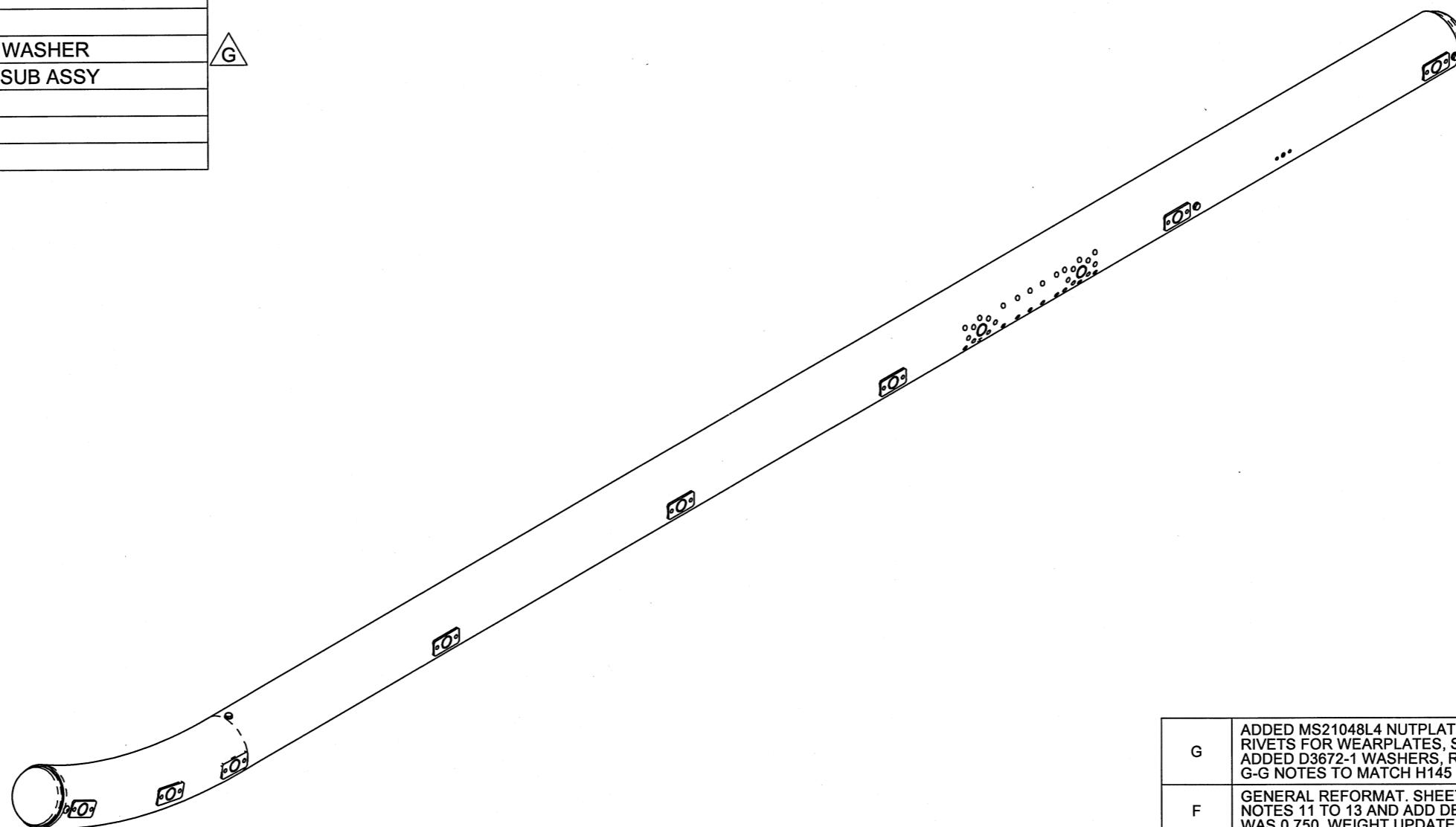


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| QTY<br>-041 | P/N           | DESCRIPTION       |
|-------------|---------------|-------------------|
| X           | D4680-041     | SKIDTUBE          |
| 1           | D2965         | CAP               |
| 1           | D2965-3       | CAP               |
| 2           | D3672-1       | PHENOLIC WASHER   |
| 1           | D4680-043     | SKIDTUBE SUB ASSY |
| 2           | AN3C5A        | BOLT              |
| 2           | AN526C1032R10 | SCREW             |
| 2           | NAS1149C0332R | WASHER            |

G



|            |  |  |              |
|------------|--|--|--------------|
| G          | ADDED MS21048L4 NUTPLATES AND CR1122-3-02.5 RIVETS FOR WEARPLATES, SEE DETAIL L AND DETAIL M, ADDED D3672-1 WASHERS, REVISED SECTION C-C AND G-G NOTES TO MATCH H145 SKIDTUBES   | ZF   | 19.03.28     |
| F          | GENERAL REFORMAT, SHEET 3: ADD ITEMS 6 & 11 ADD NOTES 11 TO 13 AND ADD DETAIL H. SHEET 5: Ø0.188 WAS 0.750. WEIGHT UPDATE. ADD PROSEAL 1422  | AJS  | 17.03.30     |
| E          | GROUND HANDLING CROSSBOLT SPACERS NOW SWAGED, WAS WELDED. REMOVED D3492-055 PLUG ASSEMBLIES  | AP   | 15.11.02     |
| D          | MOVED AFT GROUNDING FASTENER HOLE AFT 0.25 DUE TO INTERFERENCE, ADDED NOTE 9 (SHT 1), GROUNDING STRAP WASHERS NOW STAINLESS  | AP   | 15.03.04     |
| C          | NAS1149F0332P WAS AN960-10L, AN526C1032R10 WAS AN526C1032-10, FWD GROUNDING STRAP FASTENER MOVED AFT (C5-3), Ø0.750 WAS Ø0.758 (B4-3)  | AP   | 14.07.29     |
| B          | FWD CAP WAS D2965 NOW D2965-3, VARIOUS DIMENSIONAL CHANGES. D3492-055 PLUG ASSY WAS D3492-051, SWAGING DIMENSION NOW 0.650 WAS 0.661 (D6-2), ADDED DETAIL H (C2-3), MATERIAL D2962-150 WAS D2962-131 (A7-3), GROUND HANDLING THRU HOLES NOW WELDED, ADDED SECTION G-G (D3-2) | AP   | 13.09.10     |
| A          | NEW ISSUE  | AP   | 13.02.13     |
| REV.       | DESCRIPTION  | BY   | DATE         |
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| CHECKED    | MW   | DRAWING NO.  | REV. G       |
| MFG. APPR. | DD   | D4680  | SHEET 1 OF 5 |
| APPROVED   | NO   | TITLE  | SCALE        |
| DE APPR.   | DS   | SKIDTUBE   | NTS          |
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NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PAINT TOP SURFACE OF SKIDTUBE WITH MIL-W-5044 ANTI-SKID PAINT (WING WALK) AS INDICATED TO 1.00 ABOVE CENTERLINE PER QSI 005 SECTION 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4680-041" AND B/N PER QSI 044 METHOD 6.4 ON INNER RADIUS OF SKIDTUBE BEFORE INSTALLING D2965 CAP
- 7) WEIGHT: 19.7 lbs
- 8) SEAL FAYING SURFACES WITH SIKAFLEX -241/-291 OR PROSEAL 890/1422 OR MIL-S-8802 CLASS B-2 SEALANT
- 9) INSTALL FASTENERS WET WITH SIKAFLEX -241/-291 OR PROSEAL 890/1422 OR MIL-S-8802 CLASS B-2 SEALANT

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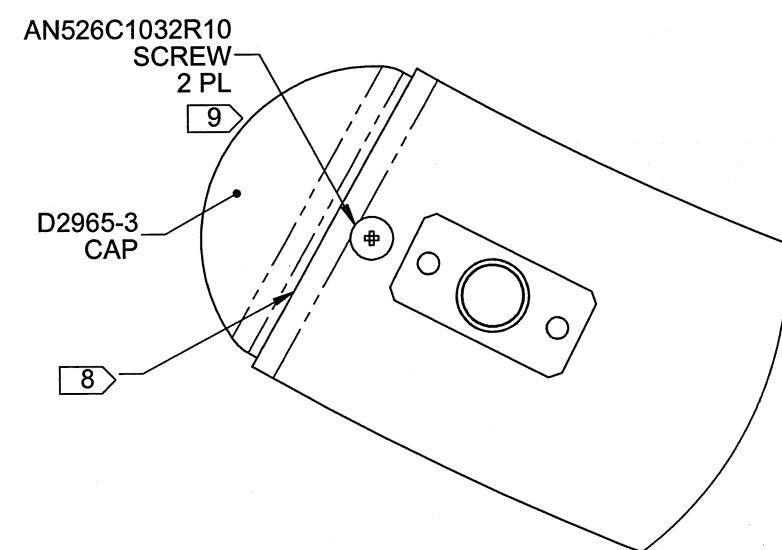
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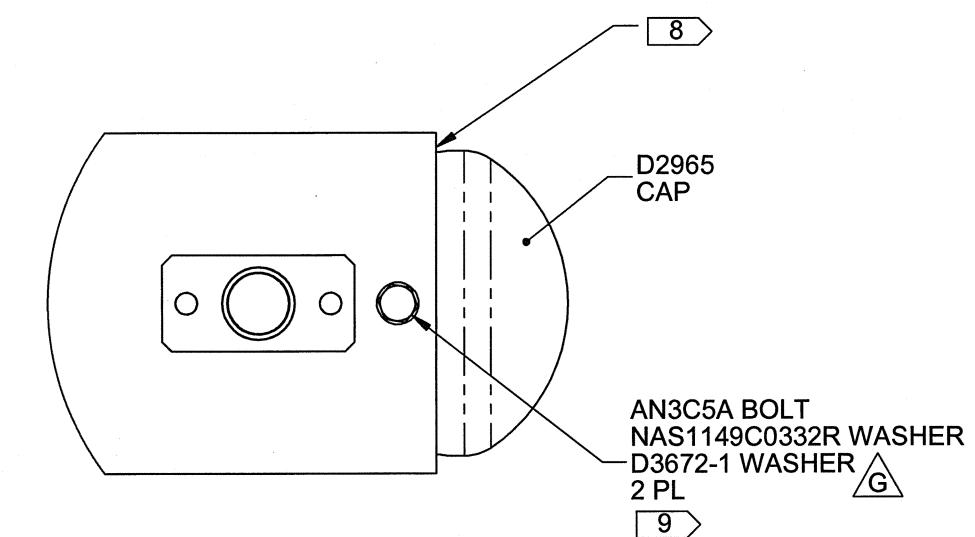
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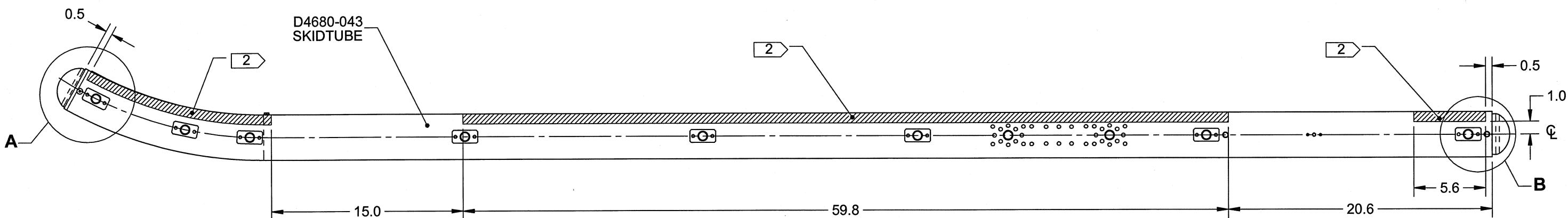
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**DETAIL A**  
SCALE 4X



**DETAIL B**  
SCALE 4X



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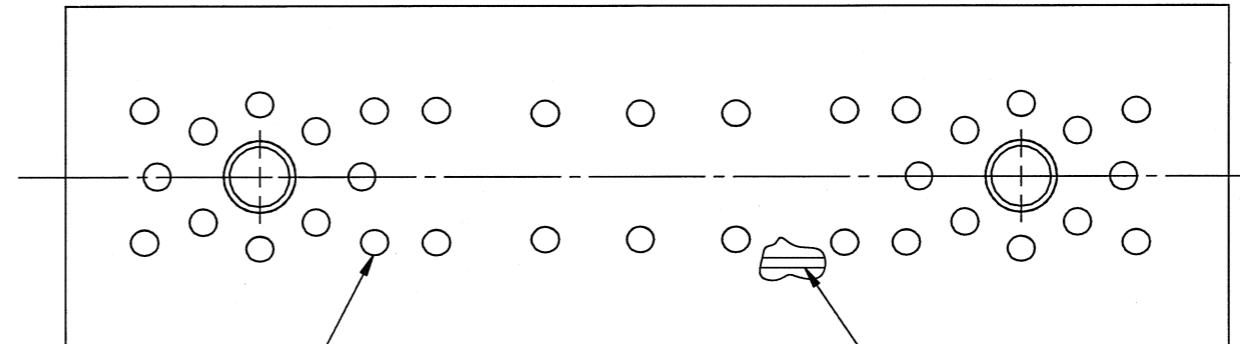
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| DE APPR.  | DS       | SHEET 2 OF 5             |     |
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| QTY<br>-043 | P/N           | DESCRIPTION           |
|-------------|---------------|-----------------------|
| X           | D4680-043     | SKIDTUBE SUB ASSY     |
| 1           | D4680-1       | SKIDTUBE              |
| 1           | D4681-041     | WEB ASSY              |
| 8           | D4686-1       | SPACER                |
| 16          | D4753-1       | DOUBLER               |
| 2           | D5304-1       | CROSSBOLT SPACER      |
| 2           | D5520-1       | DOUBLER               |
| 3           | AELS-1032-130 | INSERT                |
| 3           | AN3C4A        | BOLT                  |
| 4           | CR1122-3-02.5 | RIVET                 |
| 68          | CR3212-5-05   | CSK RIVET, CHERRY MAX |
| 32          | MS20601AD4W3  | RIVET, BLIND, CSK     |
| 2           | MS21048L4     | NUTPLATE              |
| 3           | NAS1149C0332R | WASHER                |

G

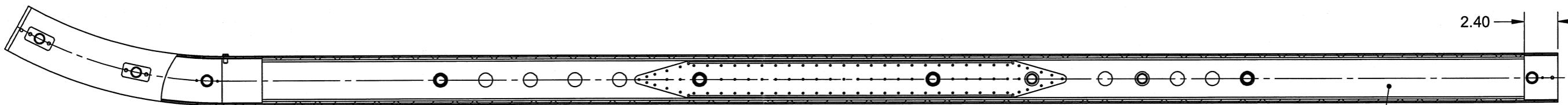
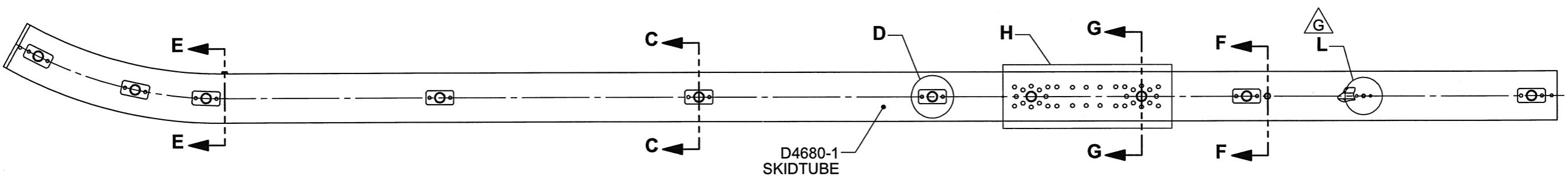
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12 11 CR3212-5-05  
CSK RIVET, CHERRY MAX  
34 PL PER DOUBLER

**DETAIL H**  
SCALE 4X

10  
D5520-1 DOUBLER  
2 PL



### D4680-043 SKIDTUBE SUB ASSY

9 D4681-041  
WEB ASSY

#### NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: APPLY CHEMICAL CONVERSION COATING PER DART QSI 005 4.1 PRIOR TO INSTALLING D4681-041 WEB.  
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 18.9 lbs
- 8) SEAL ALL MATING SURFACES USING PROSEAL 890/1422 OR MIL-S-8802 CLASS B2 SEALANT
- 9) INSERT D4681-041 WEB INTO D4680-1 SKIDTUBE IN LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND  
WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX -241/-291 ADHESIVE PER DART QSI 015
- 10) LOCATE THE D5520-1 DOUBLER USING THE Ø0.188 PILOT HOLES ON THE SKIDTUBE AND DOUBLER
- 11) LOCATE QTY (34) HOLES ONTO THE SKIDTUBE PER D5520-1 DOUBLER AND DRILL Ø0.161 THRU SKIDTUBE AND DOUBLER USING DT10309
- 12) COUNTERSINK THE SKIDTUBE Ø0.286 X 100° (34 PL) AND INSTALL EACH D5520-1 DOUBLER USING QTY (34) CR3212-5-05 CSK RIVETS

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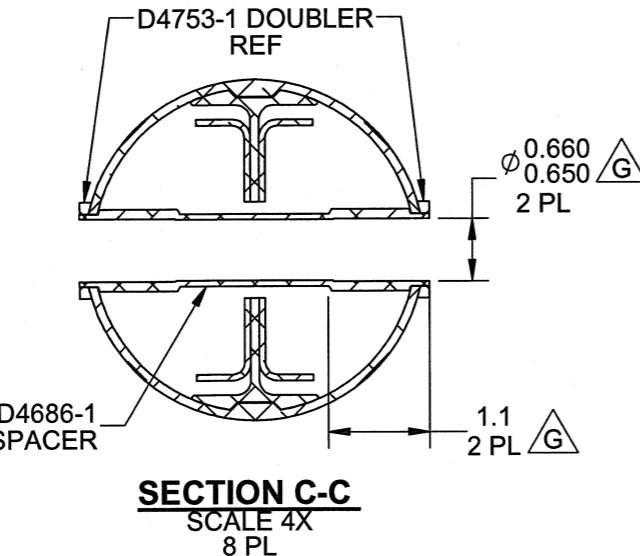
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| APPROVED      | NO | D4680  |          |
| DE APPR.      | DS | SHEET 3 OF 5                                     |          |
| DATE 19.03.28 |    | TITLE  | SKIDTUBE |
| NTS           |    |  |          |

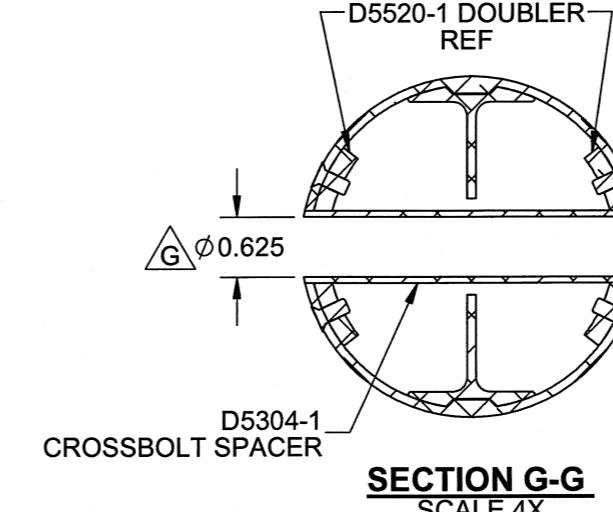
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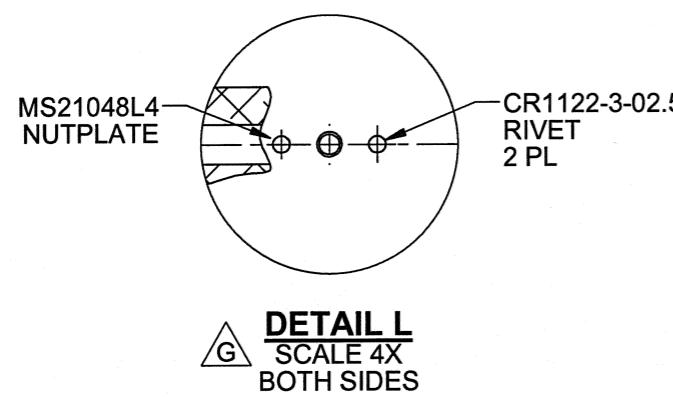
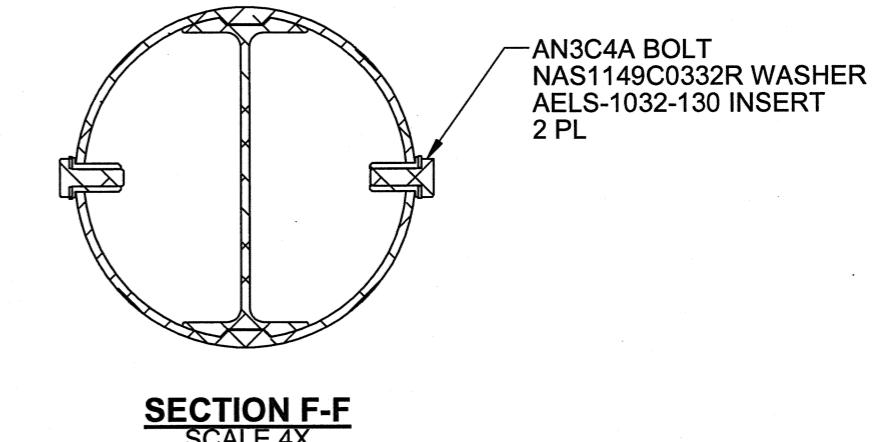
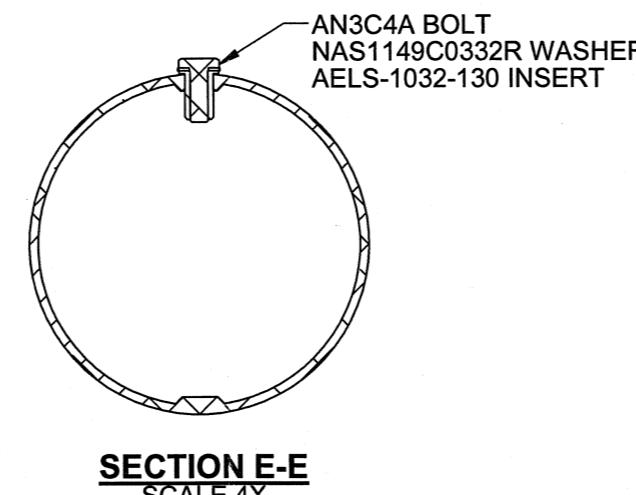
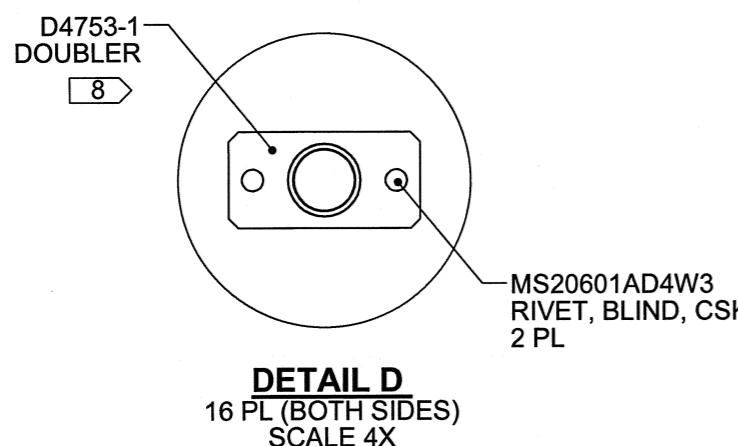
INSTALL D4686-1 SPACER AFTER INSTALLING D4753-1 DOUBLERS AS FOLLOWS:

- ⚠ G 1. REAM  $\phi 0.758$  THRU DOUBLERS AND SKIDTUBE.
- 2. INSERT D4686-1 SPACER
- 3. SWAGE TO  $\phi 0.660 / 0.650 \times 1.0$  DP EACH SIDE PER DART QSI 002
- 4. TRIM/GRIND SPACER FLUSH WITH DOUBLER PER QSI 002



INSTALL D5304-1 CROSSBOLT SPACER AFTER INSTALLING D5520-1 DOUBLERS AS FOLLOWS:

- ⚠ G 1. OPEN PILOT HOLES THRU SKIDTUBE AND DOUBLERS TO  $\phi 0.758$
- 2. INSERT D5304-1 CROSSBOLT SPACER
- 3. SWAGE TO  $\phi 0.570 / 0.565 \times 1.0$  DP EACH SIDE PER DART QSI 002
- 4. OPEN HOLE THRU SPACER TO  $\phi 0.625$



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| APPROVED  | NO       |   |
| DE APPR.  | DS       |   |
| DATE  | 19.03.28 | REV. G<br>DRAWING NO.<br>D4680<br>SHEET 4 OF 5<br>TITLE<br>SKIDTUBE<br>SCALE<br>NTS |
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